

Date: Wednesday, 11/21/2007 12:51:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOOR PROTCTOR LH	
Job Number	: 35945				
Estimate Number	: 11226				
P.O. Number	: N/A		Part Number	: D32801	
This Issue	: 11/21/2007	S.O. No. : N/A	Drawing Number	: D3280 REV B C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: SC <i>BB/07/11/22</i>	
Previous Run	: 35244		Material	: N/A	
Written By			Due Date	: 11/28/2007	
Checked & Approved By			Qty:	5 Um: Each	
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM Est RevB 07.09.12 Thermoform in house DL				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	F6006 701	lexan black
		<i>M 105952</i>
		<i>BB/07/11/22 X5</i>
Comment:	Qty.: 4.0000 sf(s)/Unit Total : 20.0000 sf(s)	
	lexan black	
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
		<i>BB/07/11/22 X5</i>
	Comment: HAND FINISHING THERMOFORMING	
3.0	THERMOFORMING	THERMOFORMING MACHINE
		<i>BB/07/11/23 X5</i>
	Comment: THERMOFORMING MACHINE	
	Thermoform as per Dwg. D32811and Folio FTA 011	
Dwg. Rev.	<i>C</i>	
Folio Rev.	<i>B</i>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>BB/07/11/26 X5 PTO -></i>
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
	Comment: HAND FINISHING THERMOFORMING	
	1) Trim to Finished Dimensions <i>BB/07/11/26 X5</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/22	4	overheated. R.c. Human error	<u>John</u> <u>asen</u>	Scrap & replace. Qty 1	<u>BB</u> <u>07/11/22</u>	<u>✓</u> <u>07/11/22</u>	<u>John</u> <u>asen</u>	<u>✓</u> <u>07/11/22</u>

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR LH

Job Number: 35945

Part Number: D32801

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

- 1) Check Surface finish for undesired marks, voids, dimples etc.
- 2) Check dimensions to ensure conformity to drawing tolerances.

SL- 07/11/26-

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 7/11/26 (X)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST272

AS 07/11/28

(X5)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ND 07/11/30

Job Completion



W.D. 11/30

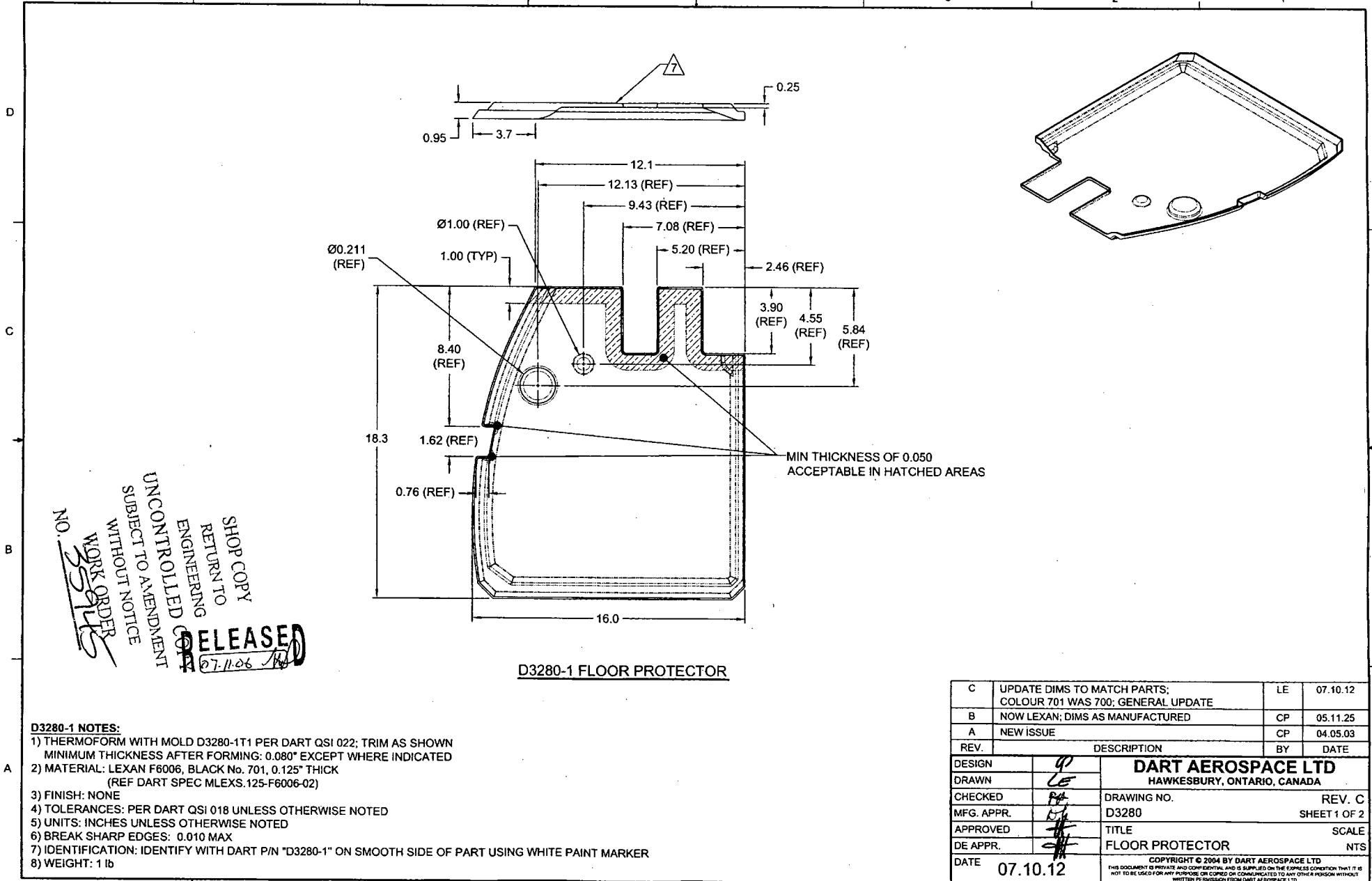
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

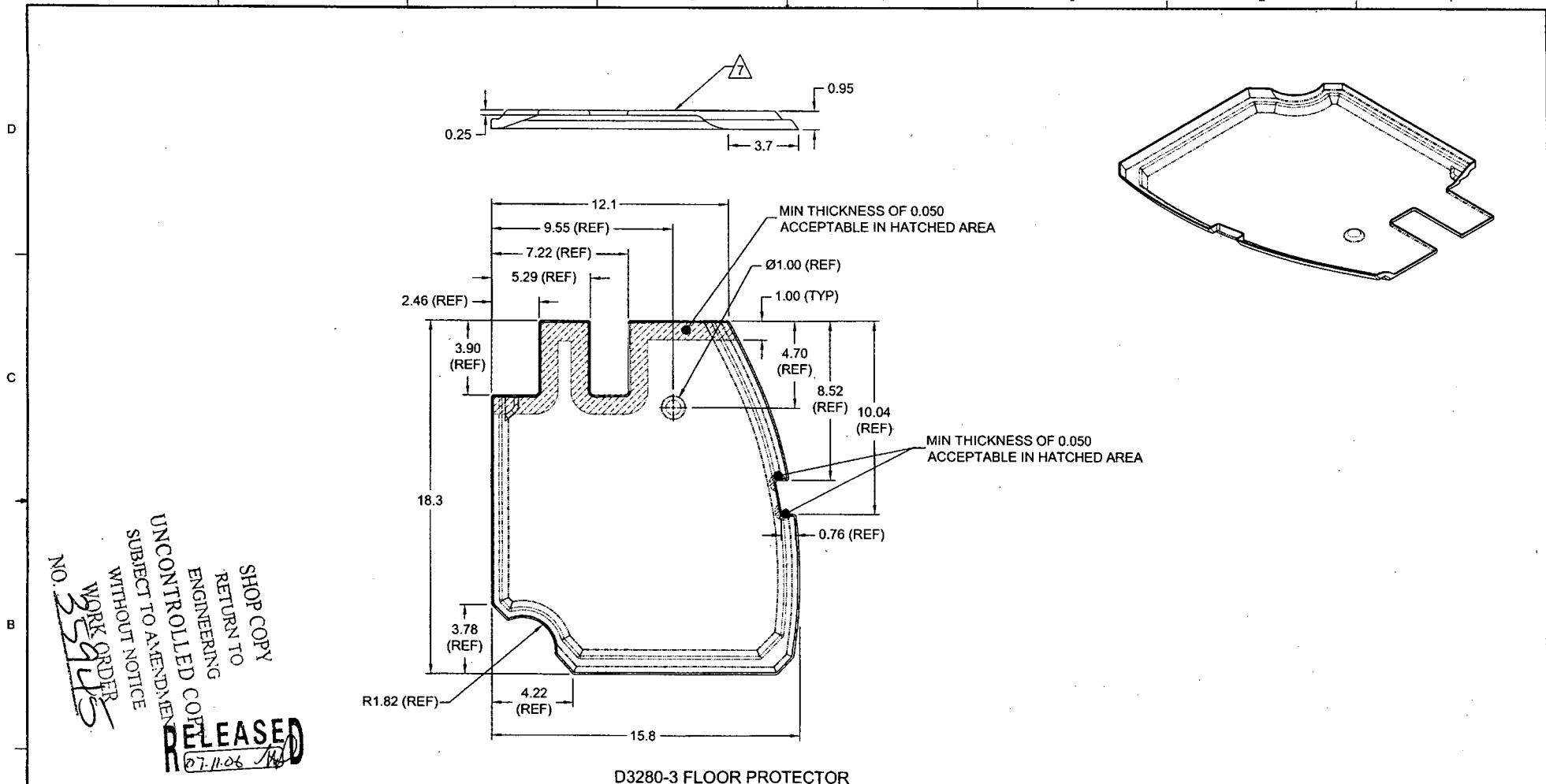
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION		
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CE		
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	LA	D3280	SHEET 1 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	FLOOR PROTECTOR	NTS
DATE	07.10.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



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NO. 25945
RELEASED
07.11.06

D3280-3 NOTES:

- 1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	QP	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	DL	D3280	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	07.10.12	COPRIGHT © 2004 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD	Work Order:	35945
Description: R32 Floor PROTECTOR LH-	Part Number:	D3280-1
Inspection Dwg: D3280 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16 "</u>	✓		Guage.	
Shape Definition	✓		V.I.S	
Texture Retention	✓		V.I.S	
Material imperfections such as bumps, cracks, voids, scratching	✓		V.I.S.	

Measured by: *Df* Date: 07.11.22.

TRIMMING SECTION

Measured by: Date: 07/11/36

Audited by: 034136 **Date:** _____

Prototype Approval: _____ **Date:** _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

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